



Dart Aerospace Ltd.
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D2171

Job Sheet 192889



DAS
21
9-89

Part No: D2171

Job Qty: 20 pcs

Part Name: Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/3/19

Job Tracking No:

Due Date: 5/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP REV:A 11.04.26 now made in house DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		5/8/19	0.00	0.74	Waterjet - Flow		02/19/06/05
120	QC 8	20 pcs		5/8/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - Brake NC - B4B	20 pcs		5/8/19	0.03	1.04	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		

DAS
40
9-89

JUN 06 2019

DAS
30
9-89

JUN 17 2019

Plex 4/3/19 11:20 AM Dart.lajeunesse.marie

Part Op **100** - 1-Cut as per Dwg
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Form as per dwg) 1- remove press and machine marking as necessary

140 - (QC5- Inspect part completeness to step on W/O) INSPECT AS PER TEMPLATE

150 - (Identify as per dwg & Stock Location:_____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.5160 sf (.0258 ea)	100-Waterjet - Flow - 1	8159674

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	288	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
2	Clamp	0.750Inches ± 0.030	0.780 0.720		
3	Clamp	0.400Inches ± 0.030	0.430 0.370		
4	Clamp	4.968Inches ± 0.010	4.978 4.958		
5	Clamp	4.158Inches ± 0.010	4.168 4.148		

Plex 4/3/19 11:20 AM Dart.lajeunesse.marie



Container No: S187931



Part: D2171

Job No: 192889

Serial No/Batch: S187931

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/05/19

Entered: LR Date: Oct 24/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7529

Route update only ☐

Job: <u>192889</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☒ Supplier ☐ Quality ☐			
Part No. <u>02171</u>					

Date: JUL 16 2019

Sequence #:

QTY Affected: 23

MRB (QSI042)

16 JUN 2019

Description Work Order Deviation - Bend is not correct which makes the tolerance between holes too big - 3.074 (1-0.010) drawing - 3.099 actual parts	Disposition - Scrap no replace	Completed By <u>DAS</u> <u>30</u> <u>9-89</u> Lead hand / Supervisor <u>DAS</u> <u>30</u> <u>9-89</u> QC / QA Coordinator <u>40</u> <u>9-89</u> <u>JUL 17 2019</u>
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Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☒ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☒ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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